

Date: Tuesday, 3/11/2008 1:17:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 37810	
Estimate Number : 12736	
P.O. Number :	Part Number : D353515
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 36653	Material :
Written By :	Due Date : 3/28/2008 Qty: 12 Um: Each
Checked & Approved By : <u>08 03 11</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM	
Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.0715 sf(s)/Unit Total : 12.8583 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 106748 HB 8-3-17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B HB 8-3-17Prog Rev: B2-Deburr if necessary HB 8-3-17

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

HB 8-3-17

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/03/18 (12)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158

3-Identify as D3535-15

SP 08/03/18

(12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 37810

Part Number: D353515

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/18 (X12)

7.0

POWDER COATING

POWDER COATING



M 106442



(12X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-1 08/03/18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-18 (X12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 17

910

08-03-18 (X12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 08/03/18

Job Completion



mc 2008/3/18

(12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order:	37810
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	*			
2.000	+/-0.010	2.000	*			
5.650	+/-0.010	5.650	*			
9.150	+/-0.010	9.150	*			
14.400	+/-0.010	14.400	*			
19.650	+/-0.010	19.650	*			
24.900	+/-0.010	24.900	*			
30.150	+/-0.010	30.150	*			
33.650	+/-0.010	33.650	*			
35.650	+/-0.010	35.650	*			
39.150	+/-0.010	39.150	>			
Ø0.188	+0.005/-0.001	.192	*			
24.00	+/-0.030	24.00	*			
16.00	+/-0.030	16.00	*			
8.00	+/-0.030	8.00	*			
5.00	+/-0.030	5.00	*			
0.300	+/-0.010	.304	*			
0.300	+/-0.010	.304	*			
0.038	+/-0.010	.034	>			

Measured by:	IB
Date:	8-3-17

Audited by:	
Date:	08/03/18

Prototype Approval:	N/A
Date:	N/A

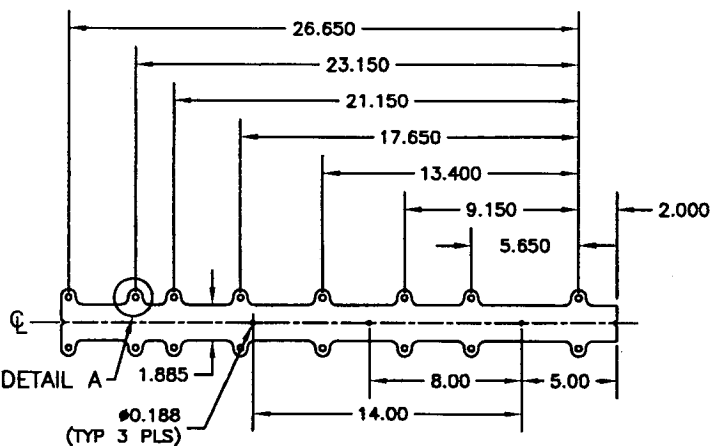
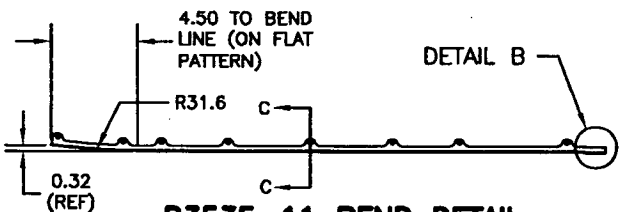
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM 	

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07.04.24

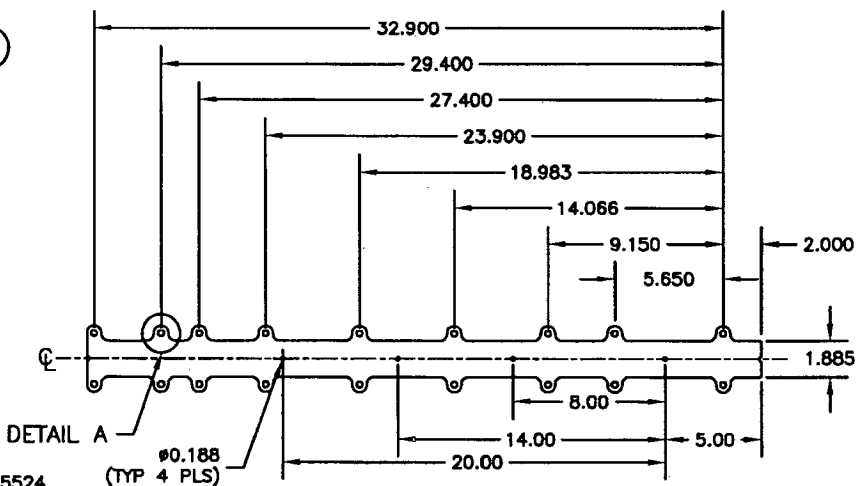
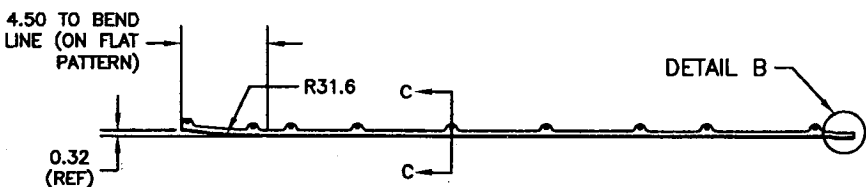
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CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

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WORK ORDER
NO. 37870

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

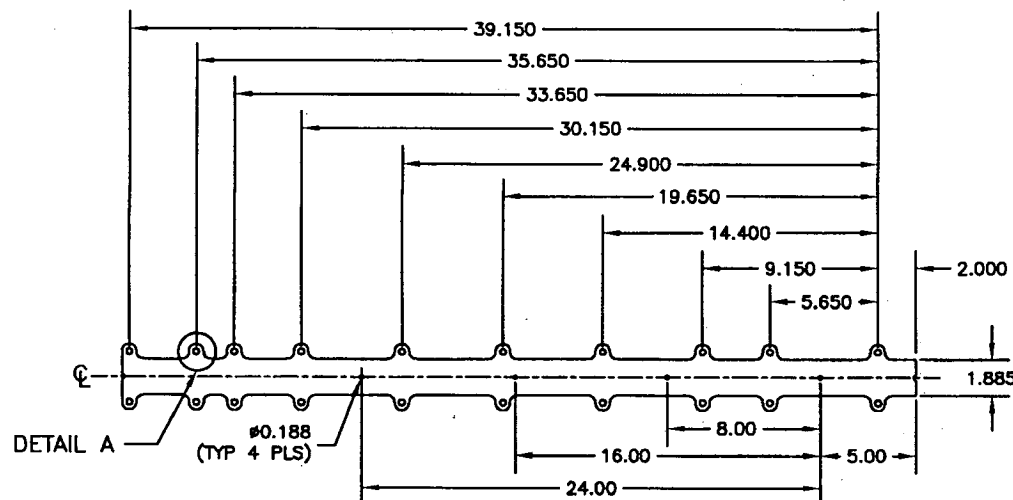
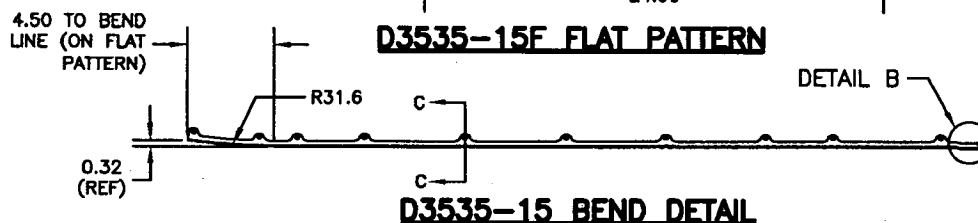
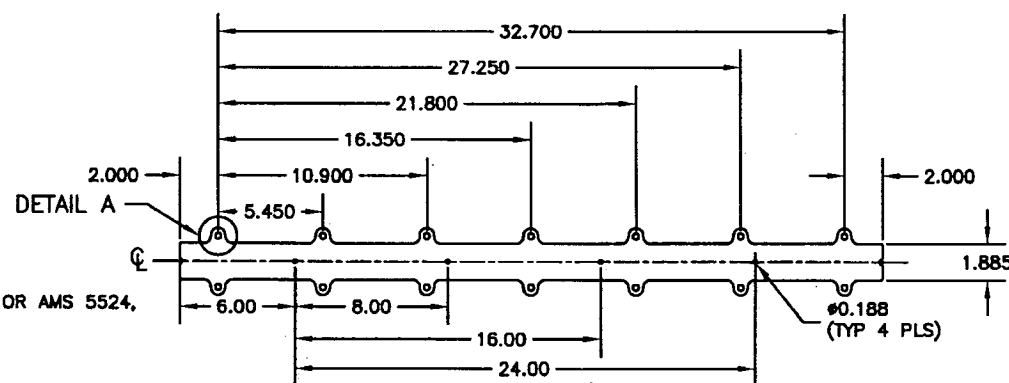
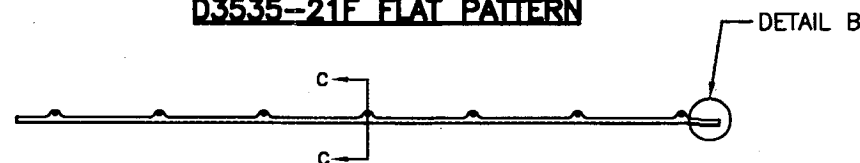
**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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<i>[Signature]</i>	<i>[Signature]</i>	D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

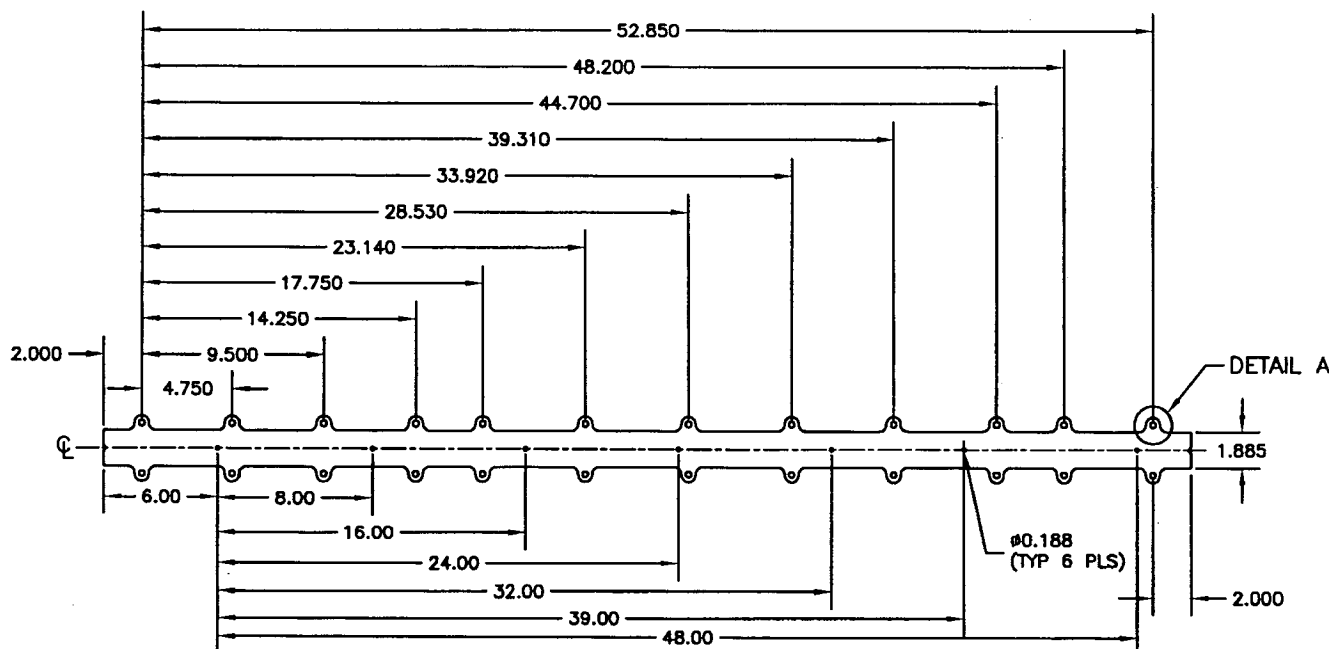
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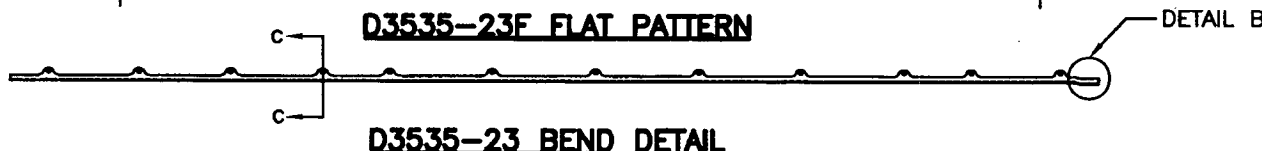
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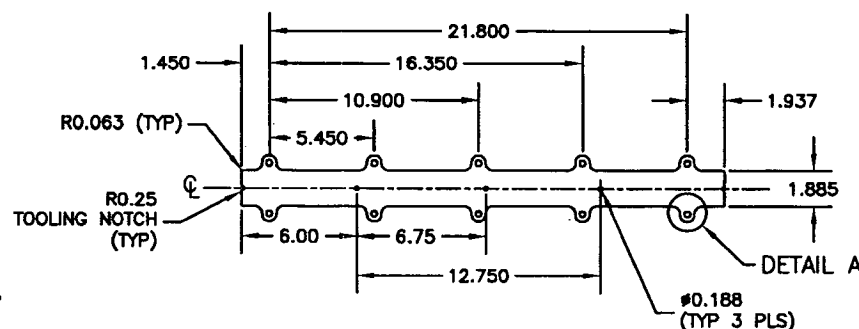
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	



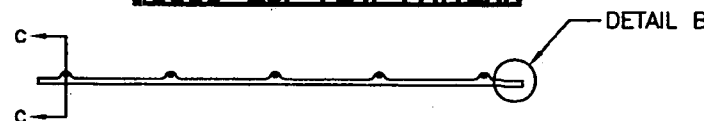
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

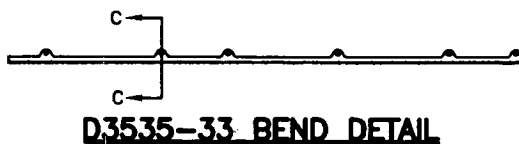
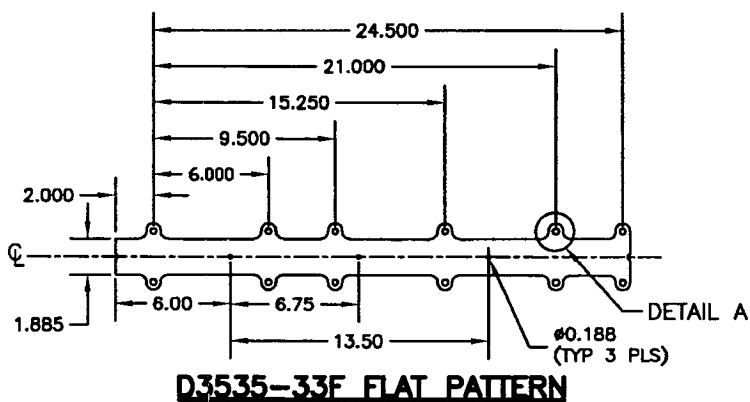
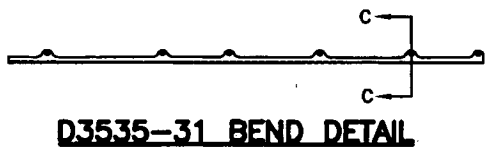
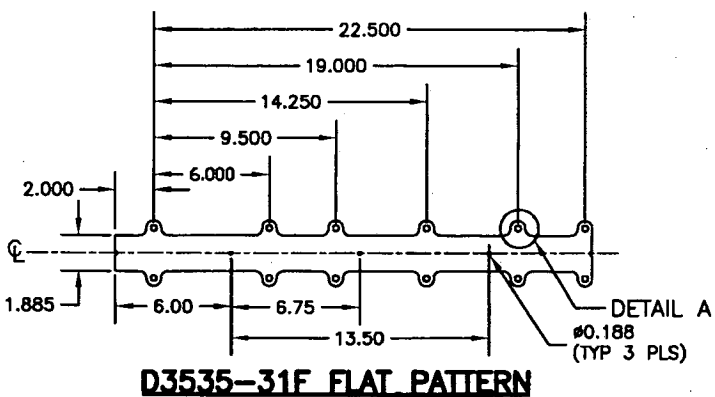
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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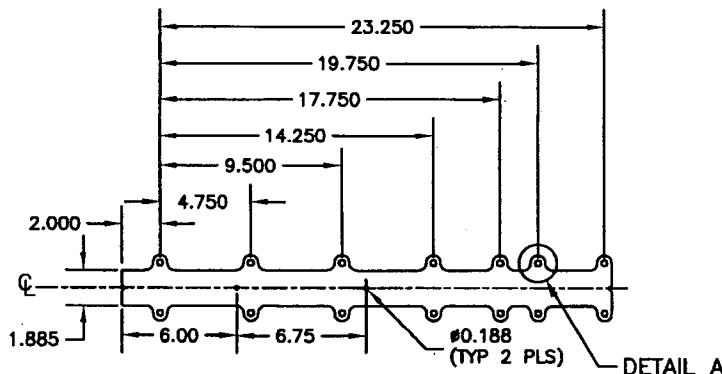
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DATE	07.04.17	TITLE	D3535	WEARSHOE	SCALE
					1:10

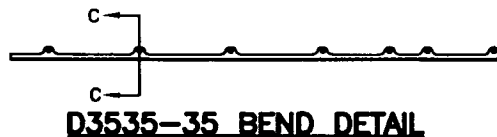
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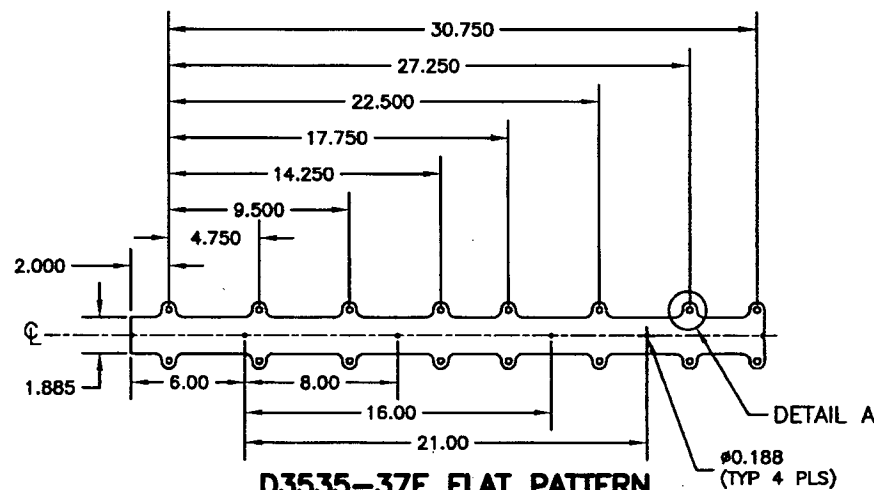
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
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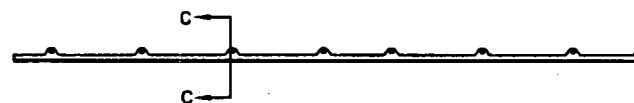
D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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NOTES

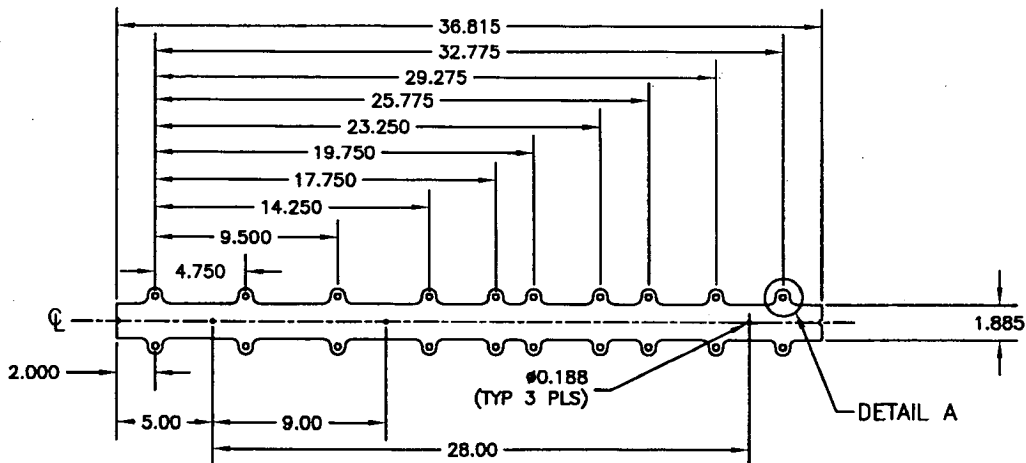
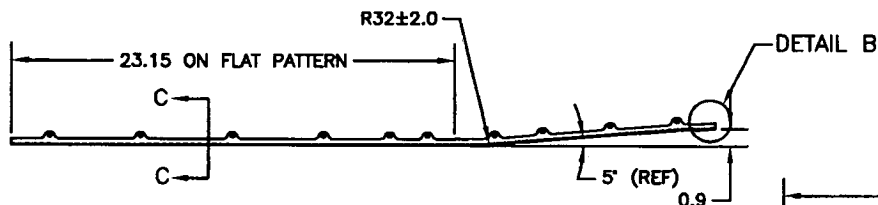
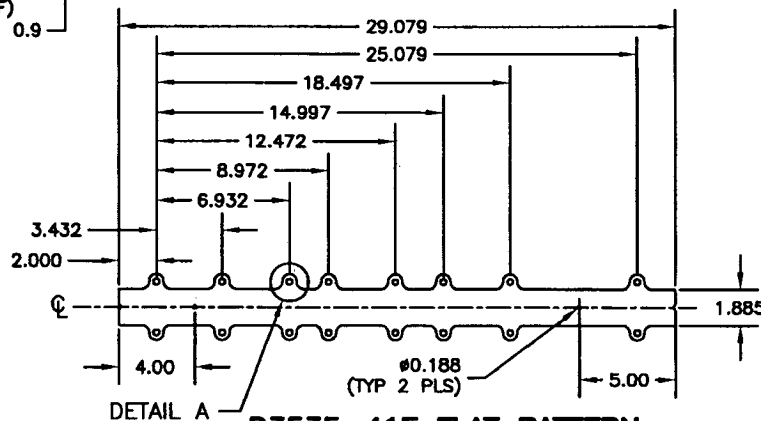
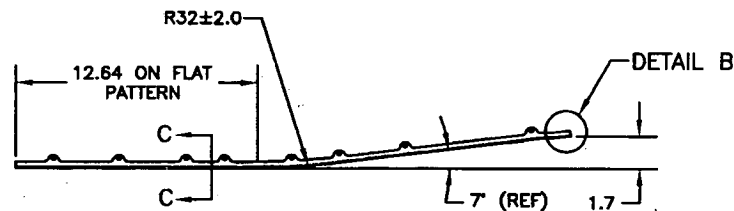
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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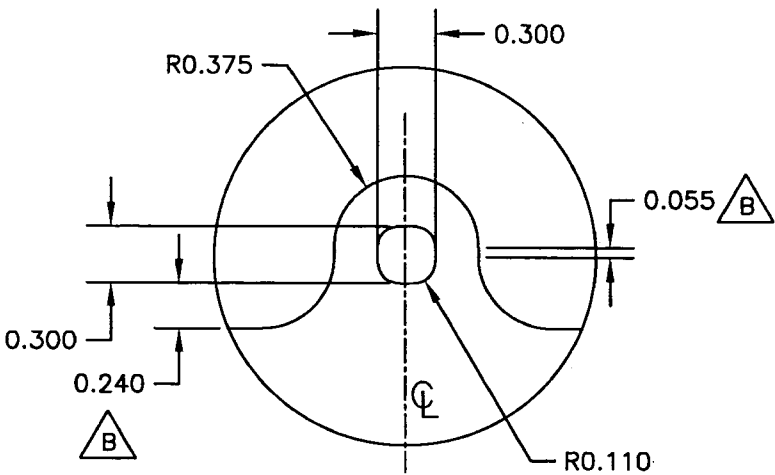
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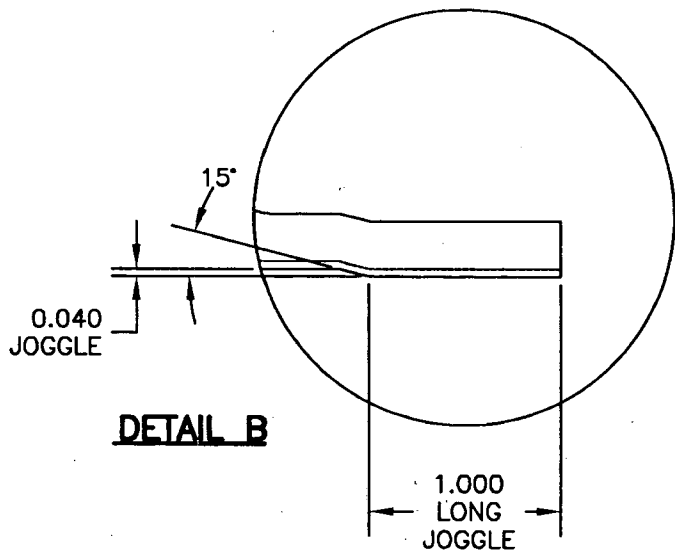
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				WEARSHOE	SCALE 1:1

RELEASED

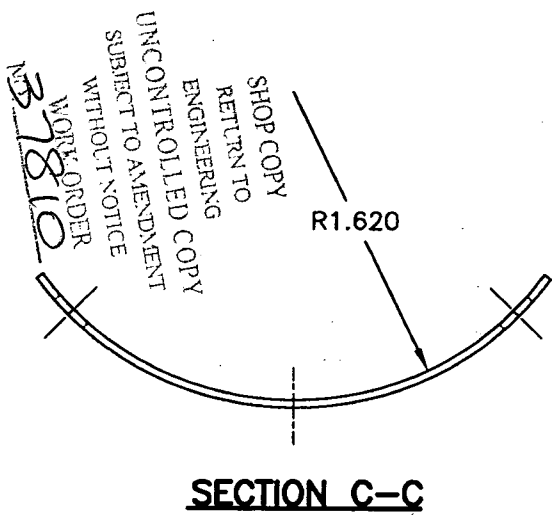
070424



DETAIL A



DETAIL B



SECTION C-C